

Work Order ID 60553



Page 1

Wednesday, July 14, 2010 8:23:34 AM

Item ID: D3838-042

Accept



Setup

Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 7/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-7-15 Tooling:

Date:

Run

Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3838	Rev A

100

0.00



Large Fab

Large Fab

Memo 0.00

Large Fab

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

SAD 10-07-27

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open
to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: M109213

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: M109213

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

EPL 10-07-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



QC5- Inspect part completeness to step on W/O

0.00

S10/07/29

QC

Memo

0.00

Quality Control

120



QC9- Inspect visual per QSI004- Fusion Welds

0.00

② 10/07/29

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: CWA

0.00

SAD
10-07-29

Packaging

Memo

0.00

Packaging

②

W/O:		WORK ORDER CHANGES					
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Page 3

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Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 7/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	Barcode
	QC:	Date:	SPC (Y/N):	Date:		Stop	Barcode

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	QC21- Final Inspection - Work Order Release	0.00						10/07/2010 JJ	
QC Quality Control	Memo	0.00						10-7-29 (2)	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 14, 2010 8:23:38 AM

Page 1

Work Order ID: 60553



Parent Item: D3838-042



Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1



Manufactured

No

100

Each

91.0000

1

2

Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	91	
54072	9	
60190	40	
60241	42	

M304TS0.750W.065



Purchased

No

100

f

308.0040

1.0317

2.172

304 SQ Tube .75x.75x.065W

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	1.4628	
112398	0	
114482	1.4628	
WA	306.541185	
114520	306.541185	

2.172

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

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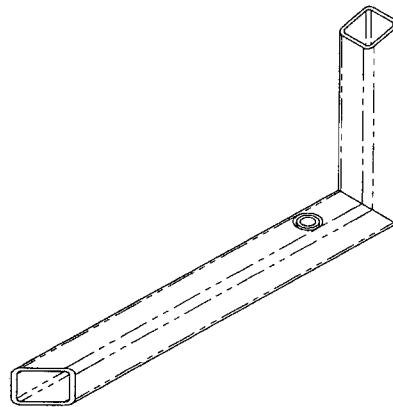
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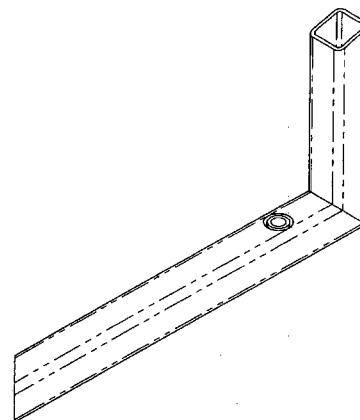
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2

1



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1	1	D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 60553

BD10-715

RELEASED
(08/11/08)

A	NEW ISSUE	MB	08.10.08
REV.		BY	DATE
DESIGN	<i>b</i>	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>NS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AM</i>	D3838	SHEET 1 OF 3
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	RIB ASSY (BASKET LID) NTS	
DATE	08.10.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.54 lbs

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1

D

D

C

C

B

B

A

A

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

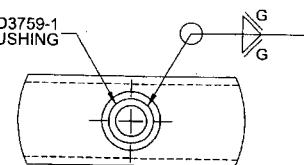
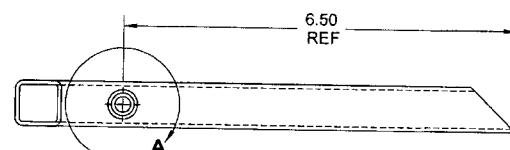
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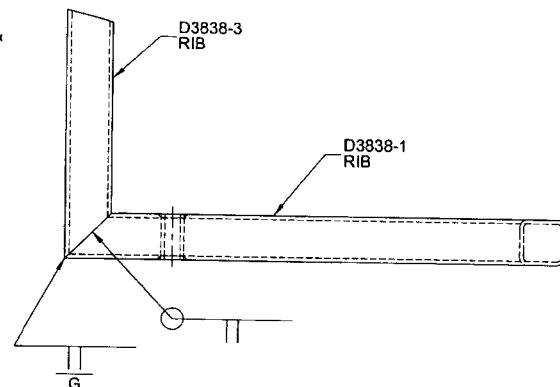
NOTE: Date & initial all entries

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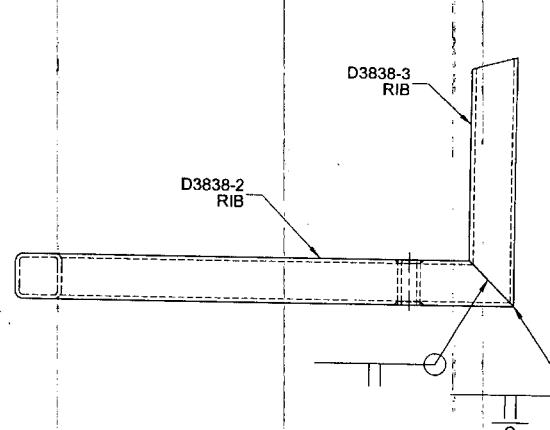
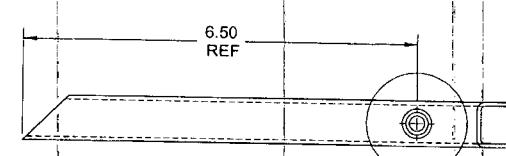
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DETAIL A
D7-2 SCALE 2X



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, LH)

RELEASED
(08/11/08 M)

w/o 40553

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>ASS</i>	DRAWING NO.
MFG. APPR.	<i>ND</i>	D3838 REV. A
APPROVED	<i>ND</i>	TITLE SHEET 2 OF 3
DE APPR.	<i>ND</i>	RIB ASSY (BASKET LID) NTS
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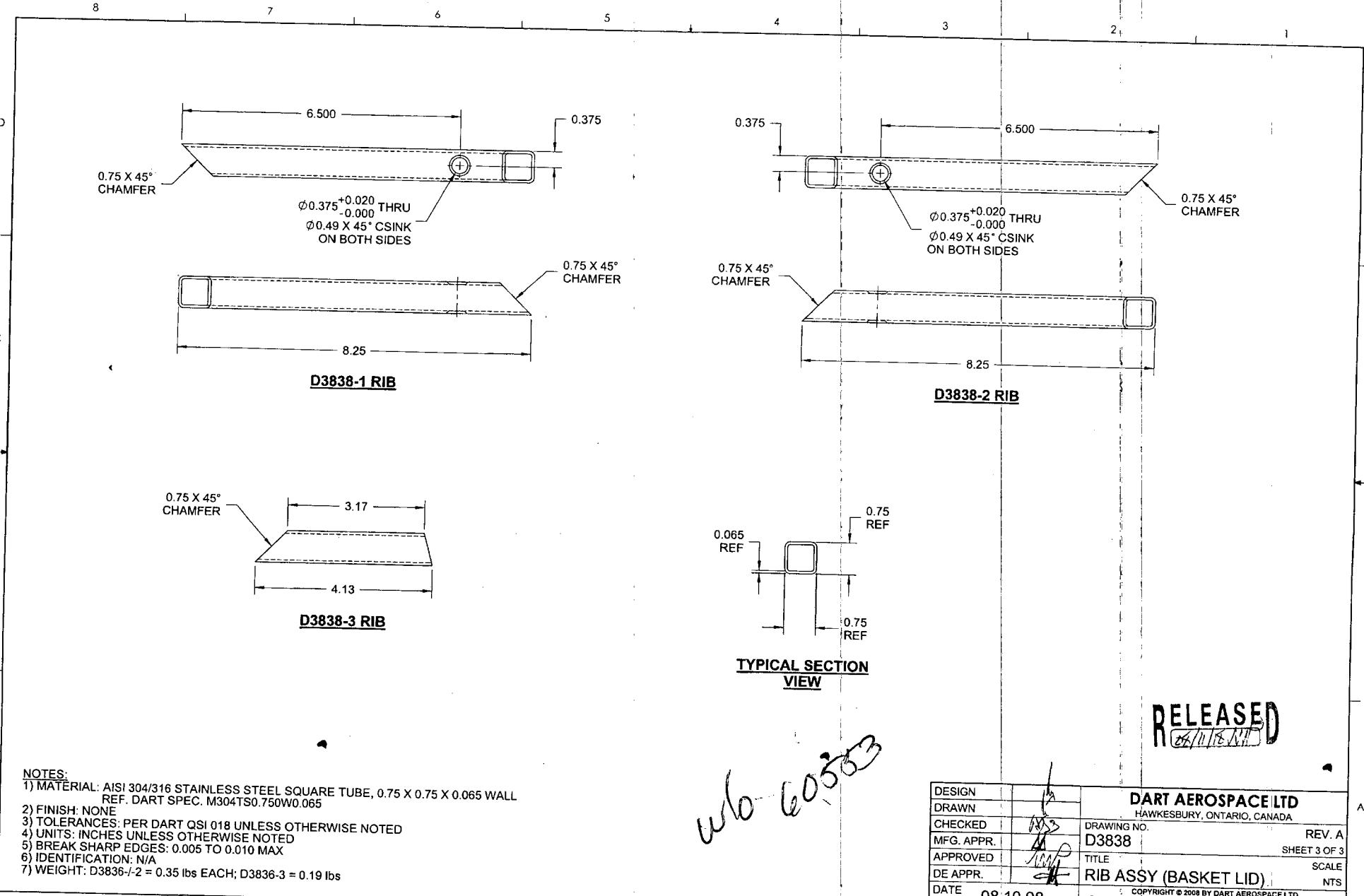
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10-60353

DESIGN	1A	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	1X3	DRAWING NO.
MFG. APPR.	1M	REV. A
APPROVED	1M	SHEET 3 OF 3
DE APPR.	1M	TITLE
DATE	08.10.08	SCALE
		RIB ASSY (BASKET LID)
		NTS

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08/11/08

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